

Date: Wednesday, 11/06/2008 12:47:27 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 39820		
Estimate Number	: 10709		
P.O. Number	:	Part Number	: D32101
This Issue	: 11/06/2008 S.O. No. :	Drawing Number	: D3210 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 33116	Material	:
Written By	:	Due Date	: 13/06/2008
Checked & Approved By	:	Qty:	12 Um: Each
Comment	: Est Rev:A New Issue 05-11-17 JLM Est Rev:B Now On Waterjet 06-10-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
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Comment: Qty.: 2.6177 sf(s)/Unit Total : 31.4118 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.080" thick
 (M2024T3S.080) Identify as D3210-1
 Batch: 107460 HB 8-6-11

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3210
 Dwg Rev: A
 Prog Rev: A

HB 8-6-11



2-Deburr if necessary

HB 8-6-11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

808/66/10 (x12)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

2/1 Done up step #27
 808/66/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/06/2008 12:47:27 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 39820

Part Number: D32101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/06/12 (12)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/06/12 (12)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00 a.m.
320 °F
11:30 a.m.

M102316

MF 08/06/12 (12x)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/06/12 (12)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 210

8/6/13

(12x)

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/13

Job Completion



MF 08-06-13



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 03.09.03	TITLE DOUBLER	REV. A SHEET 1 OF 1 SCALE 1:3
A	03.09.03	NEW ISSUE

D3210-1 DOUBLER

MAKE PER DRAWING FILE "D3210-A1.DWG"

CHECK PER TEMPLATE D3210-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

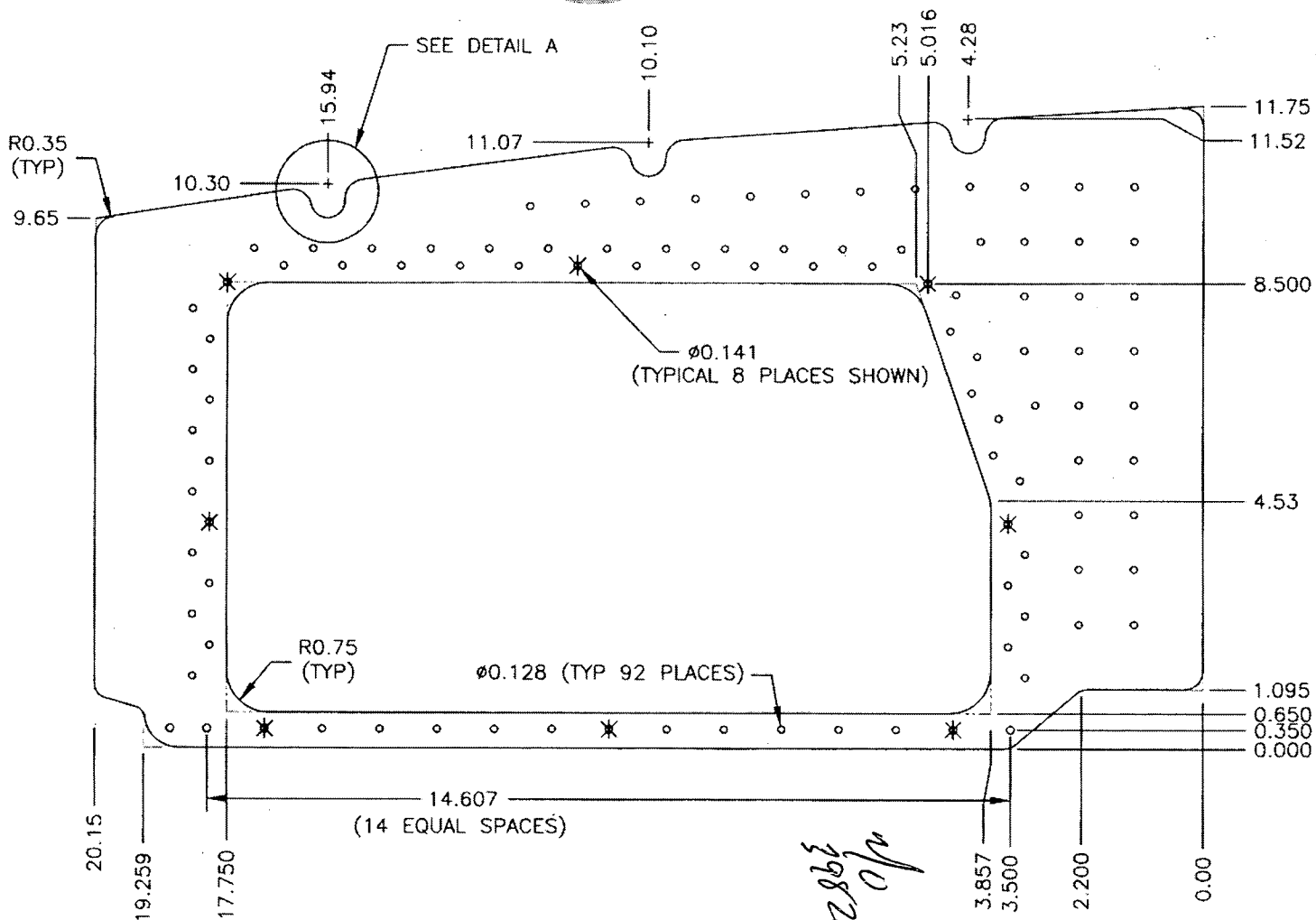
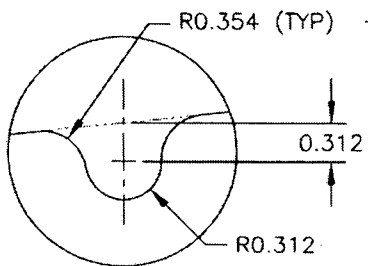
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER

DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DETAIL A
SCALE 2:3



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DART AEROSPACE LTD		Work Order: 39820
Description: DOUBLER		Part Number: D3210-1
Inspection Dwg: D3210-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .128	+ .005 - .001	.127	X			
Ø .141	+ .005 - .001	.144	X			
11.75	+/- .030	11.75	*			
8.500	+/- .010	8.500	*			
4.53	+/- .030	4.53	X			
1.095	+/- .010	1.096	*			
.650	+/- .010	.658	X			
.350	+/- .010	.350	*			
9.65	+/- .030	9.65	*			
20.15	+/- .030	20.15	X			
17.750	+/- .010	17.750	*			
3.857	+/- .010	3.863	X			
3.500	+/- .010	3.495	X			
2.200	+/- .010	2.200	X			
5.016	+/- .010	5.016	X			

Measured by: VR	Audited by: S	Prototype Approval: R
Date: 8-6-11	Date: 08/06/12	Date: 1/9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	